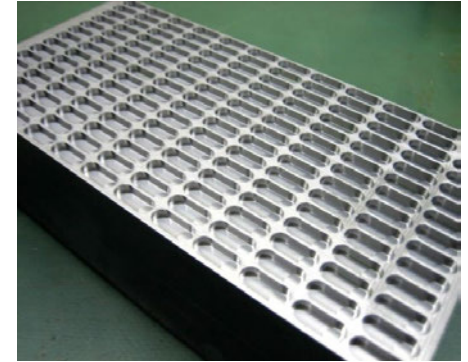
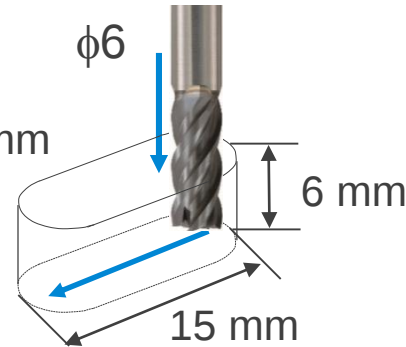


# CZS Slit milling example

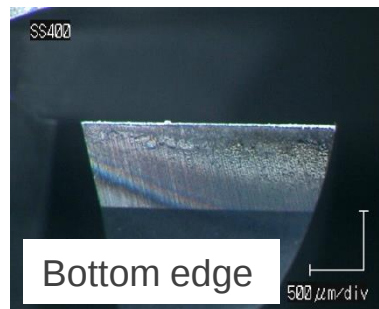
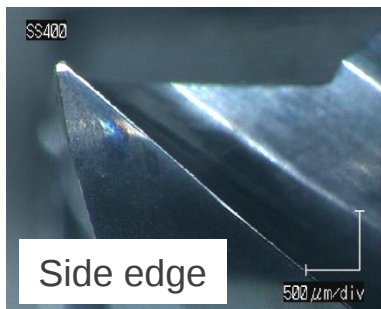
Tool : **CZS 4060-1300** ( $\phi 6 \times 13$ )  
 Work material : SS400  
 Size : Width 6 x Length 15 x Depth 6 mm



## Milling condition

| Condition                           | 1        | 2        | 3         | 4         | 5         | 6         | 7                    |
|-------------------------------------|----------|----------|-----------|-----------|-----------|-----------|----------------------|
| Spindle Speed ( $\text{min}^{-1}$ ) | 5,000    | 4,000    | 4,000     | 5,000     | 5,000     | 5,000     | 5,000                |
| Z-Feed Rate (mm/min)                | 700      | 560      | 600       | 1,050     | 1,050     | 1,050     | 1,050                |
| XY-Feed Rate (mm/min)               | 300      | 240      | 150       | 300       | 200       | 150       | 300                  |
| $a_p$ (mm)                          | 6        | 6        | 6         | 3         | 3         | 3         | 3                    |
| Coolant                             | Air blow | Air blow | Air blow  | Air blow  | Air blow  | Air blow  | Water soluble        |
| Result                              | 37 slits | 16 slits | 180 slits | 180 slits | 220 slits | 204 slits | 500 slits + $\alpha$ |

## Tool after milling with condition 7



**When milling SS400, the bottom edges might be damaged due to chip clogging in vertical milling.**

**We recommend to limit the depth to 0.5D (3 mm) and use water-soluble cutting oil to ensure lubricity.**